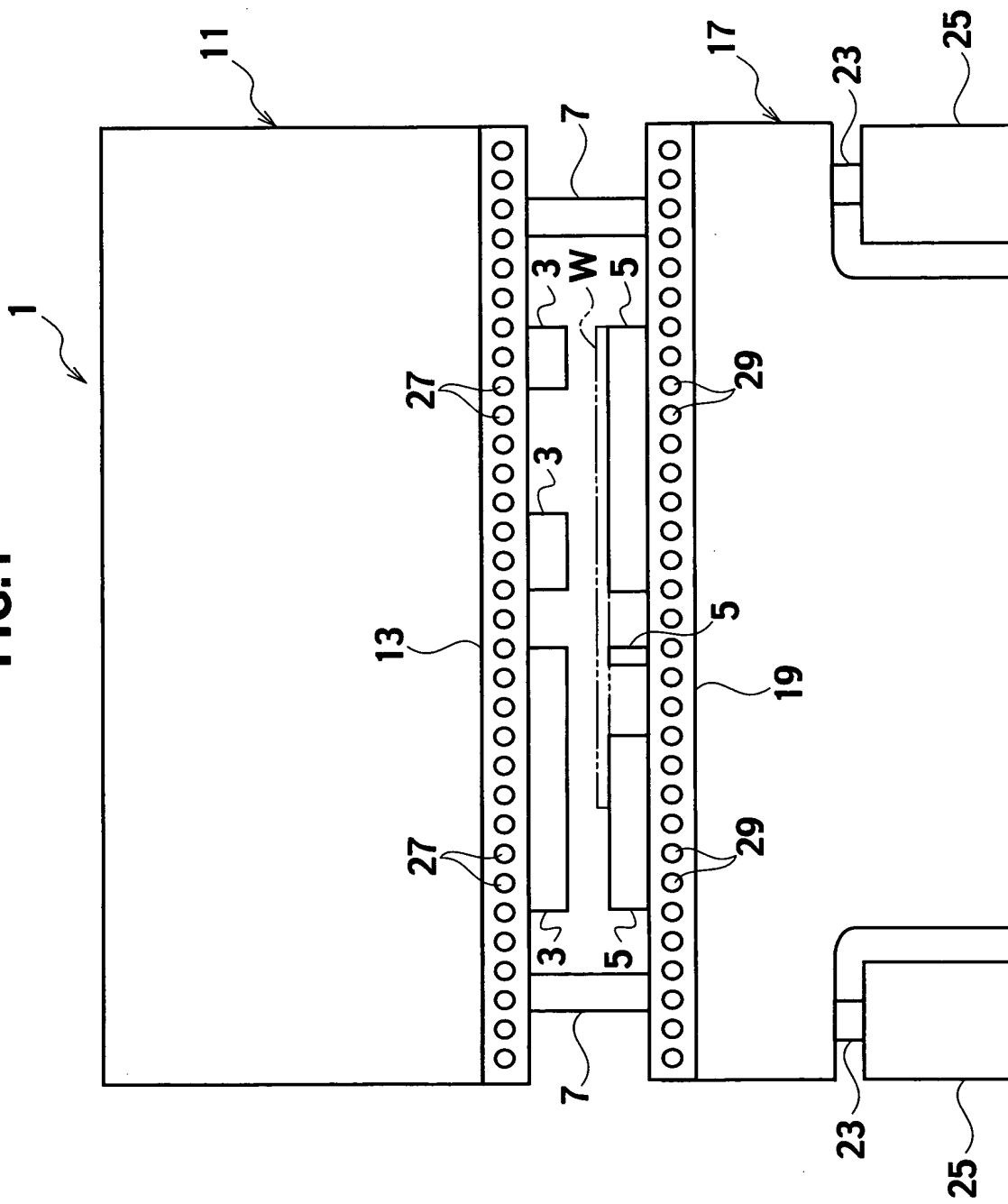


FIG.1



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FIG.2

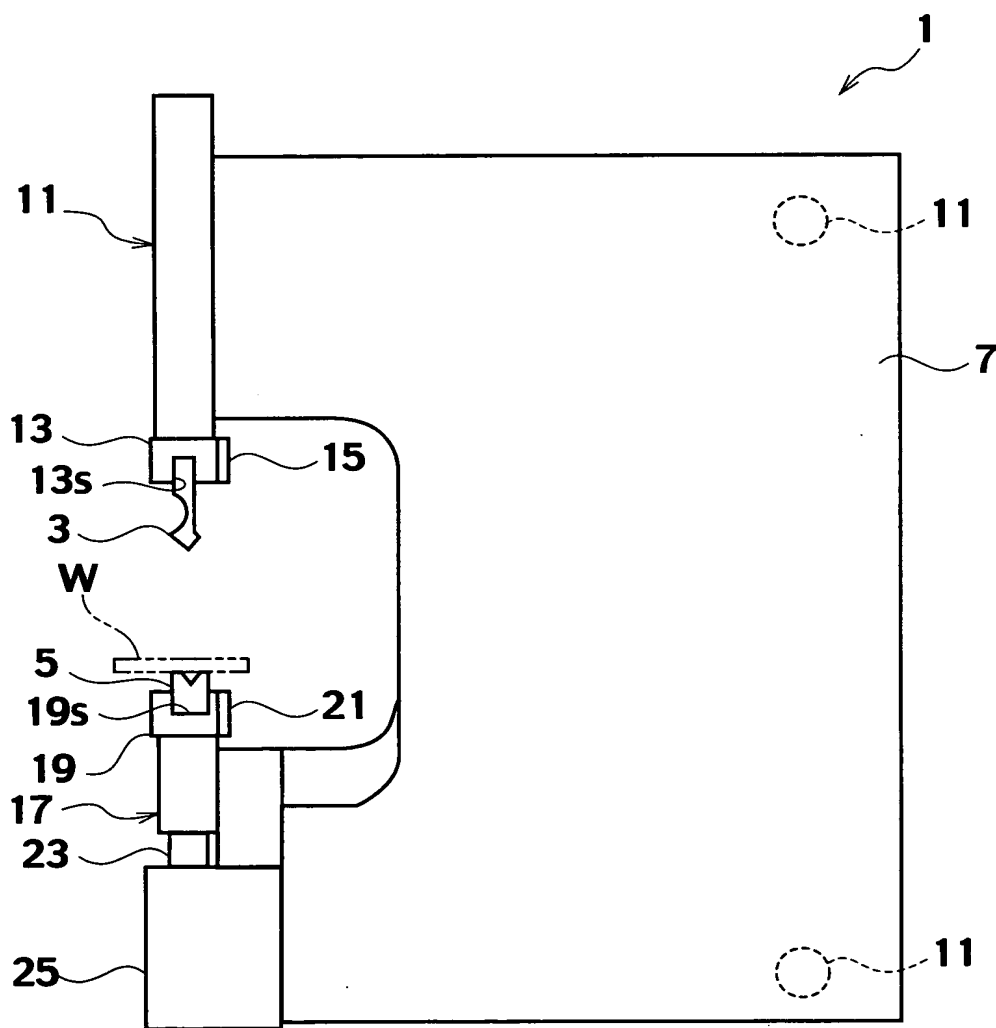


FIG.3

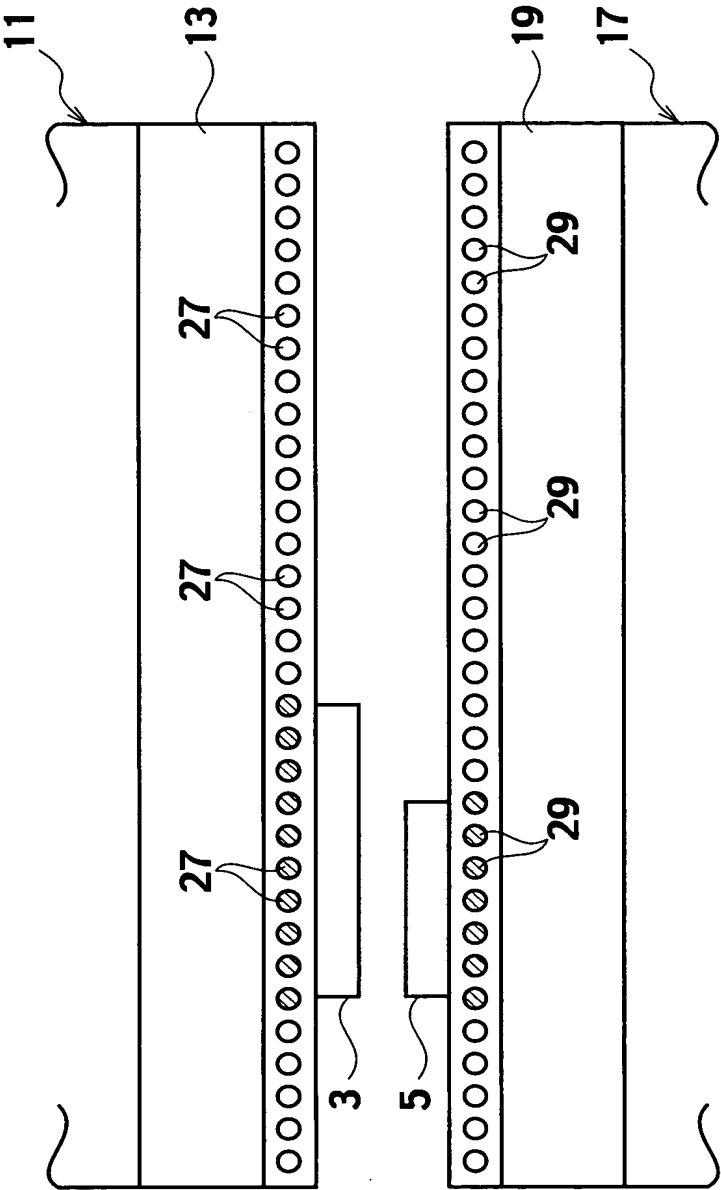
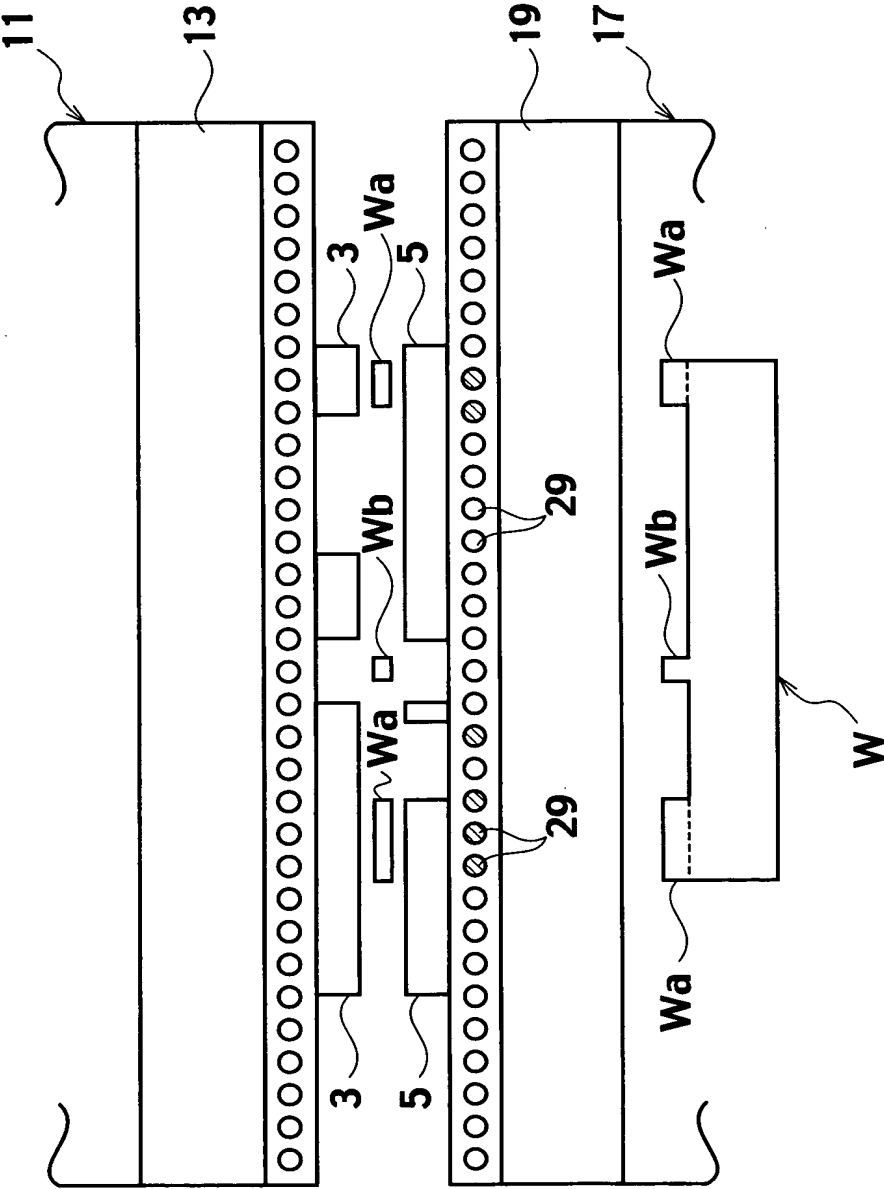
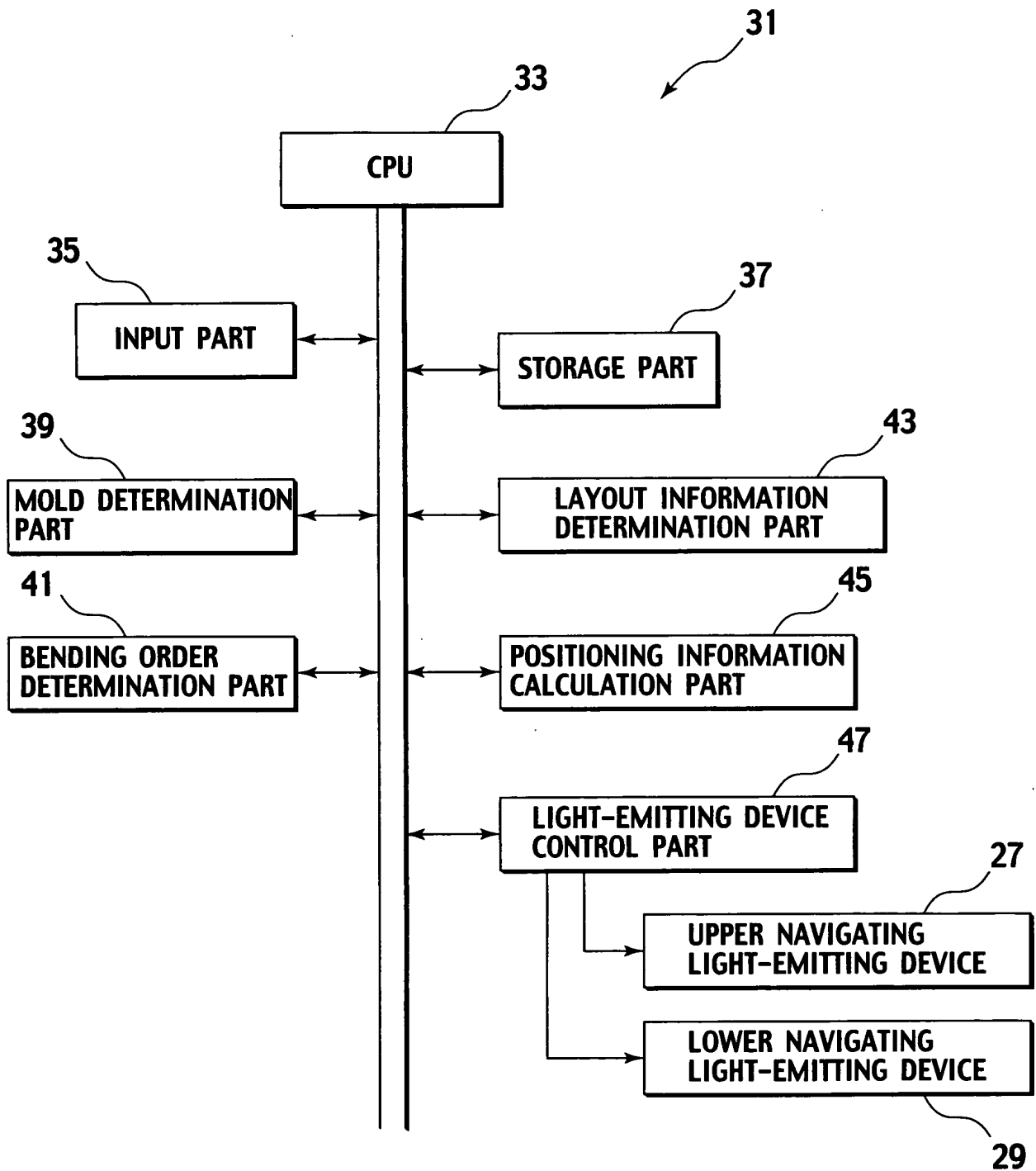


FIG.4



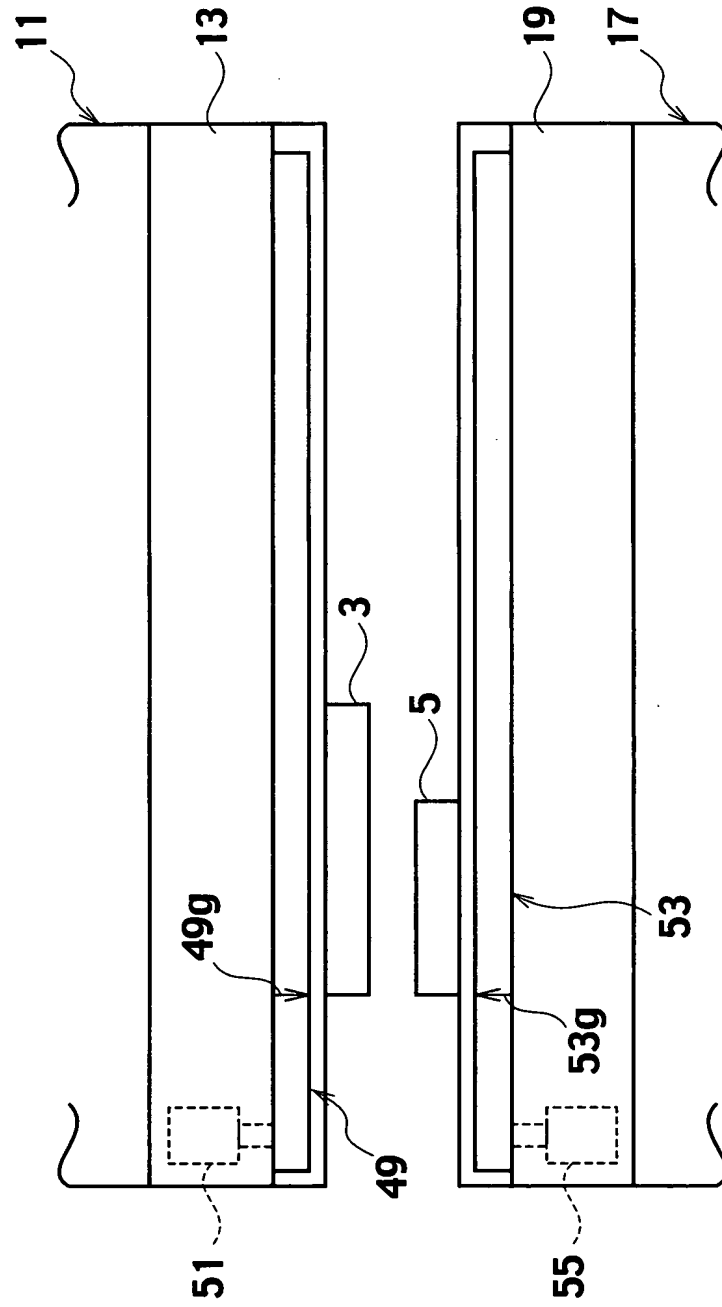
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FIG.5



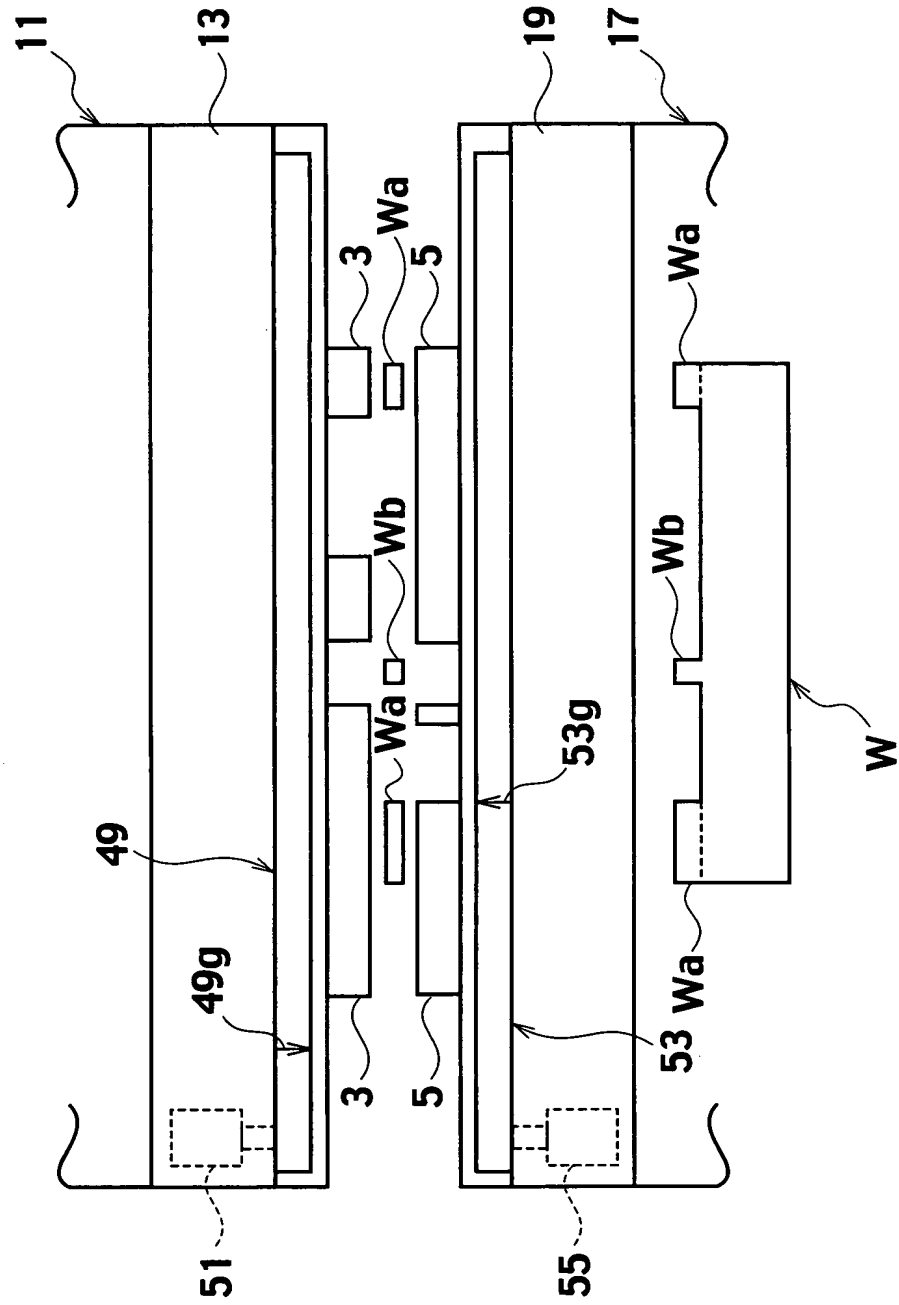
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FIG. 6



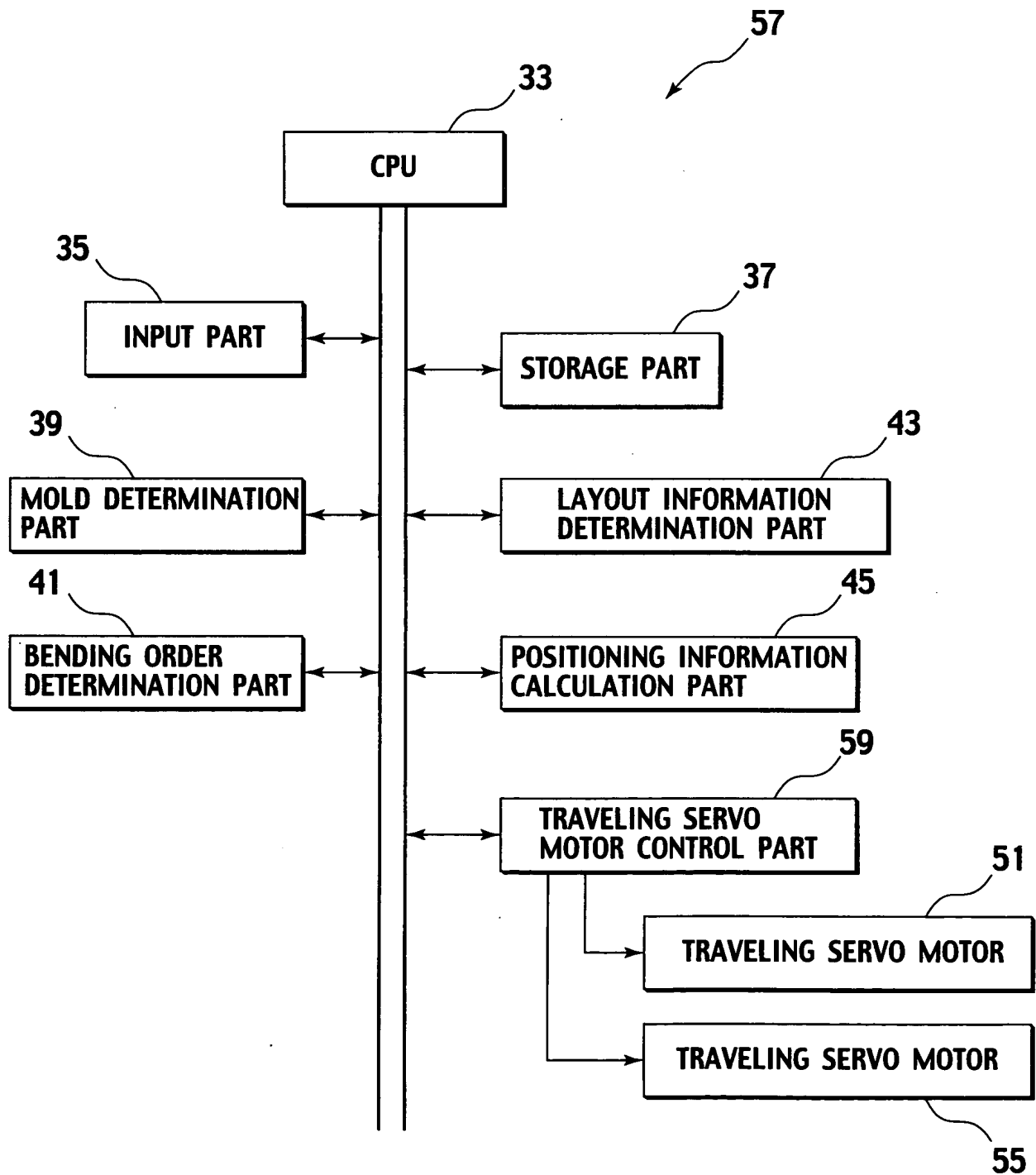
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FIG. 7



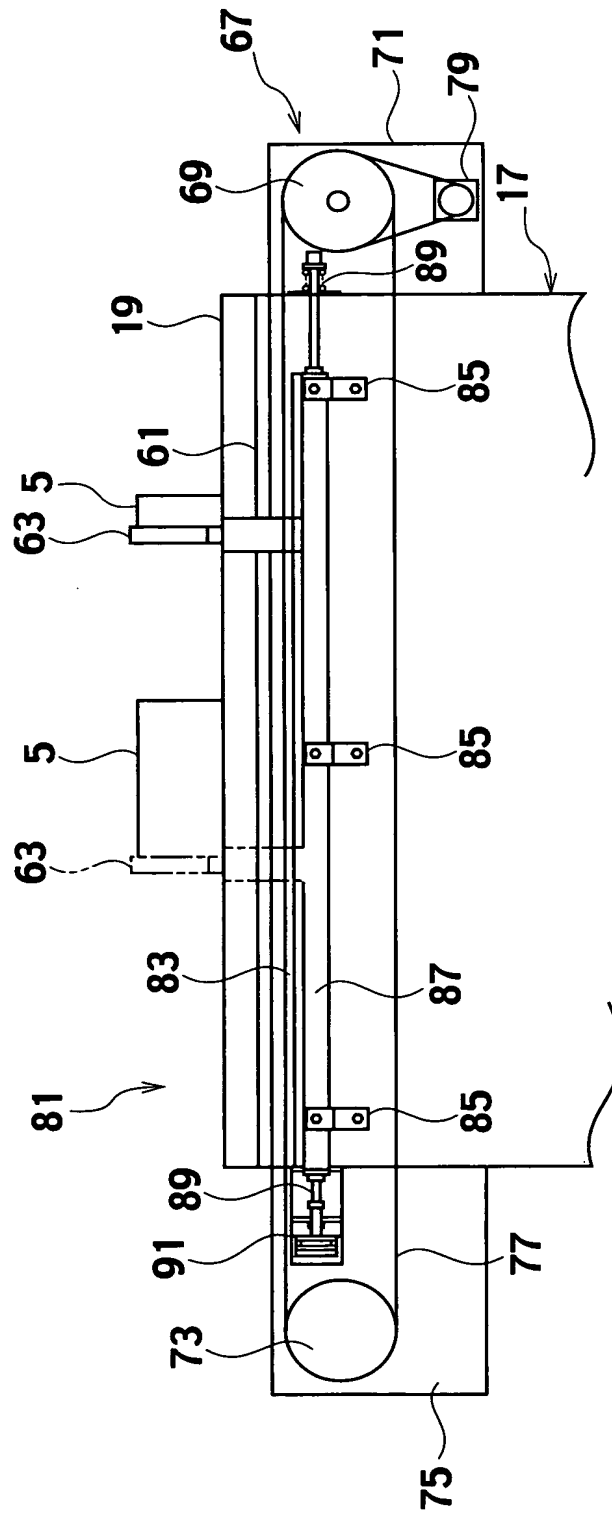
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FIG.8



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FIG.9



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FIG. 10

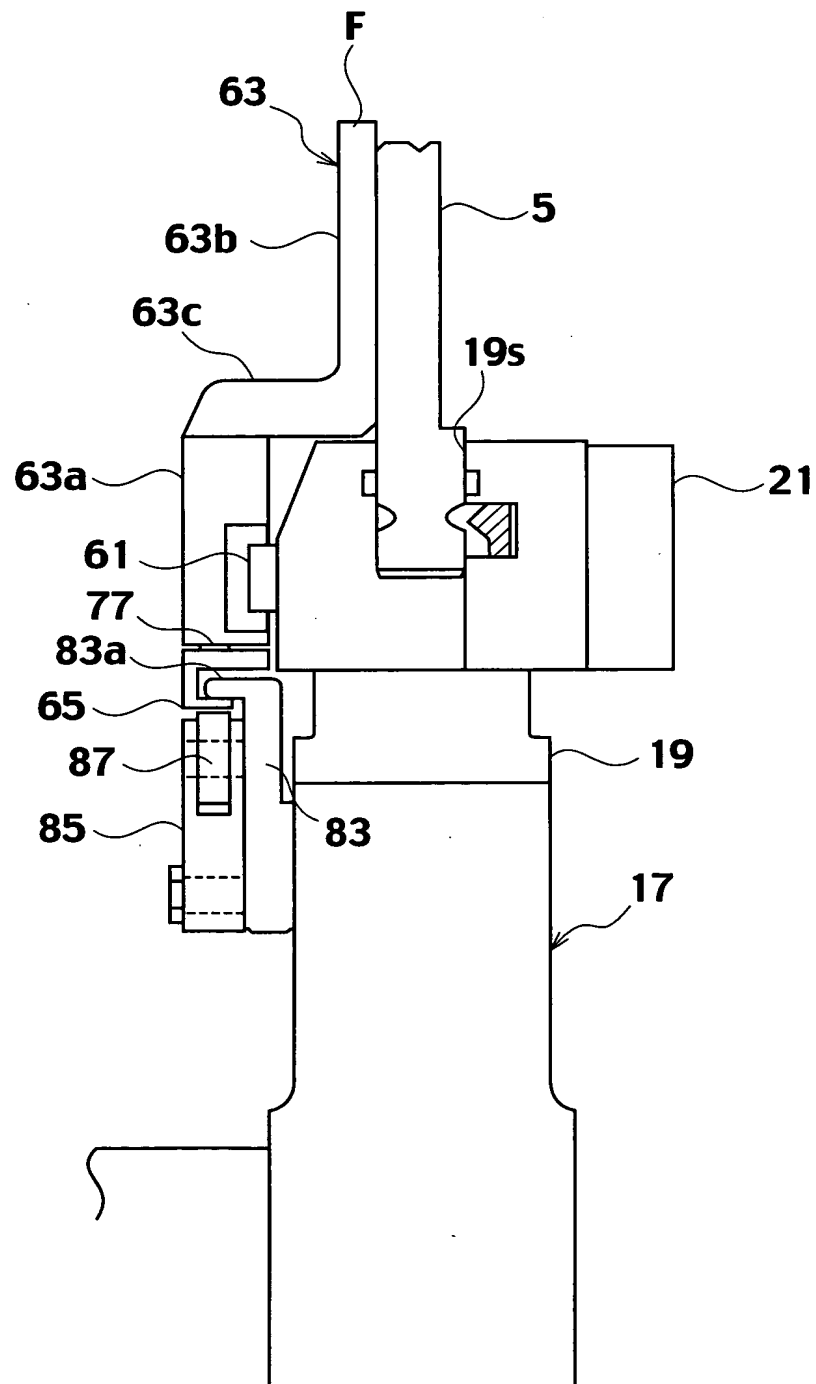
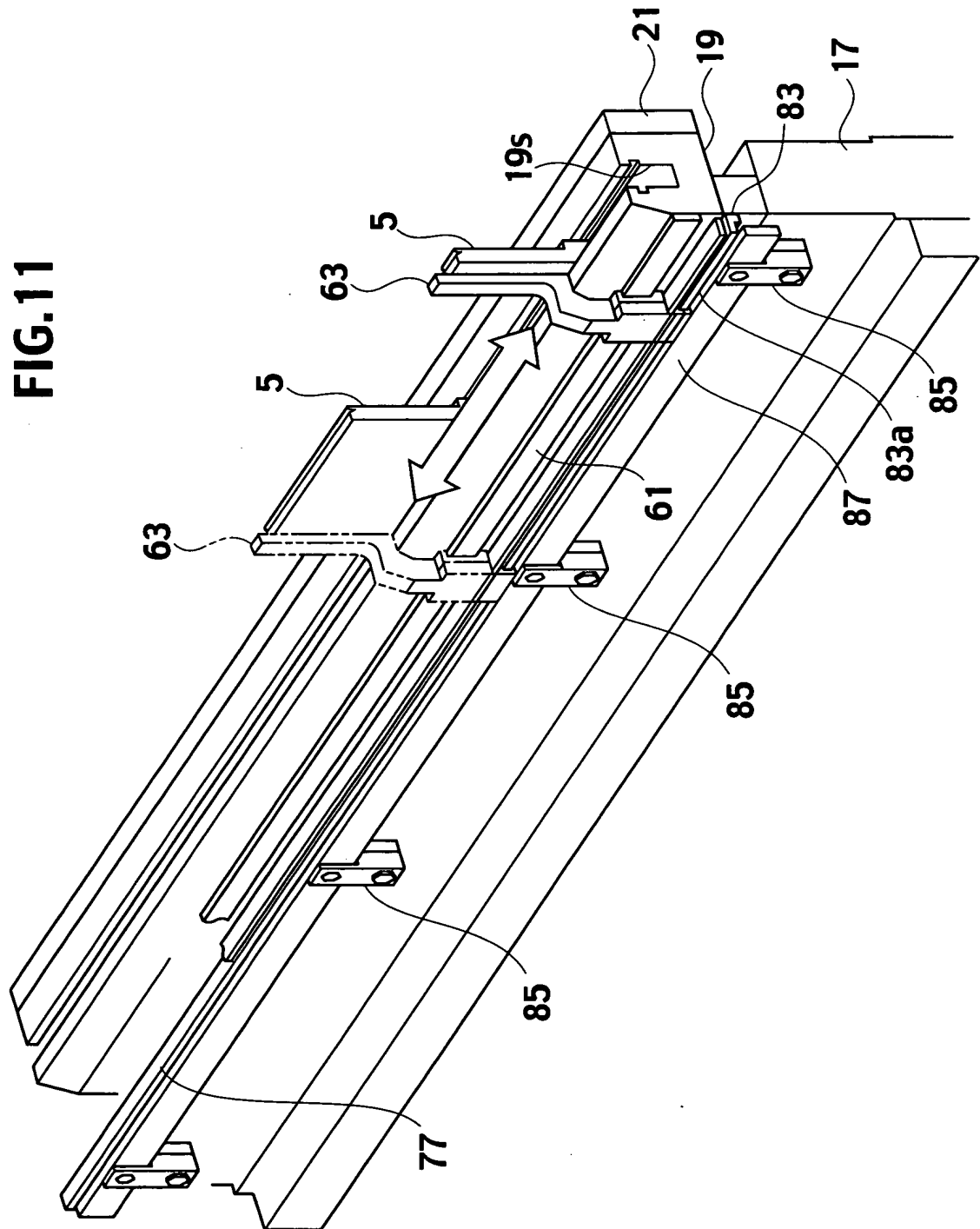
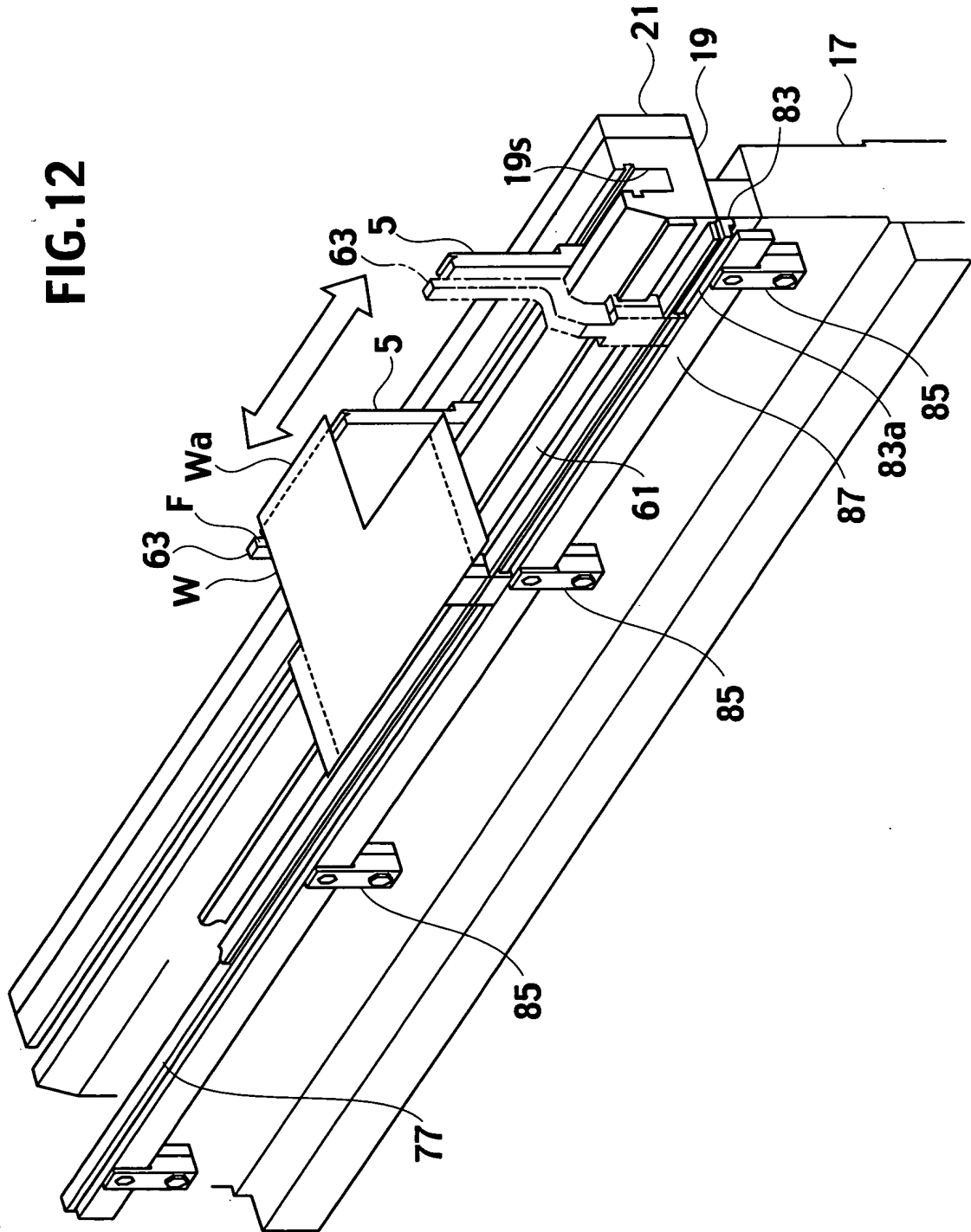


FIG. 11



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FIG. 12



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FIG. 13

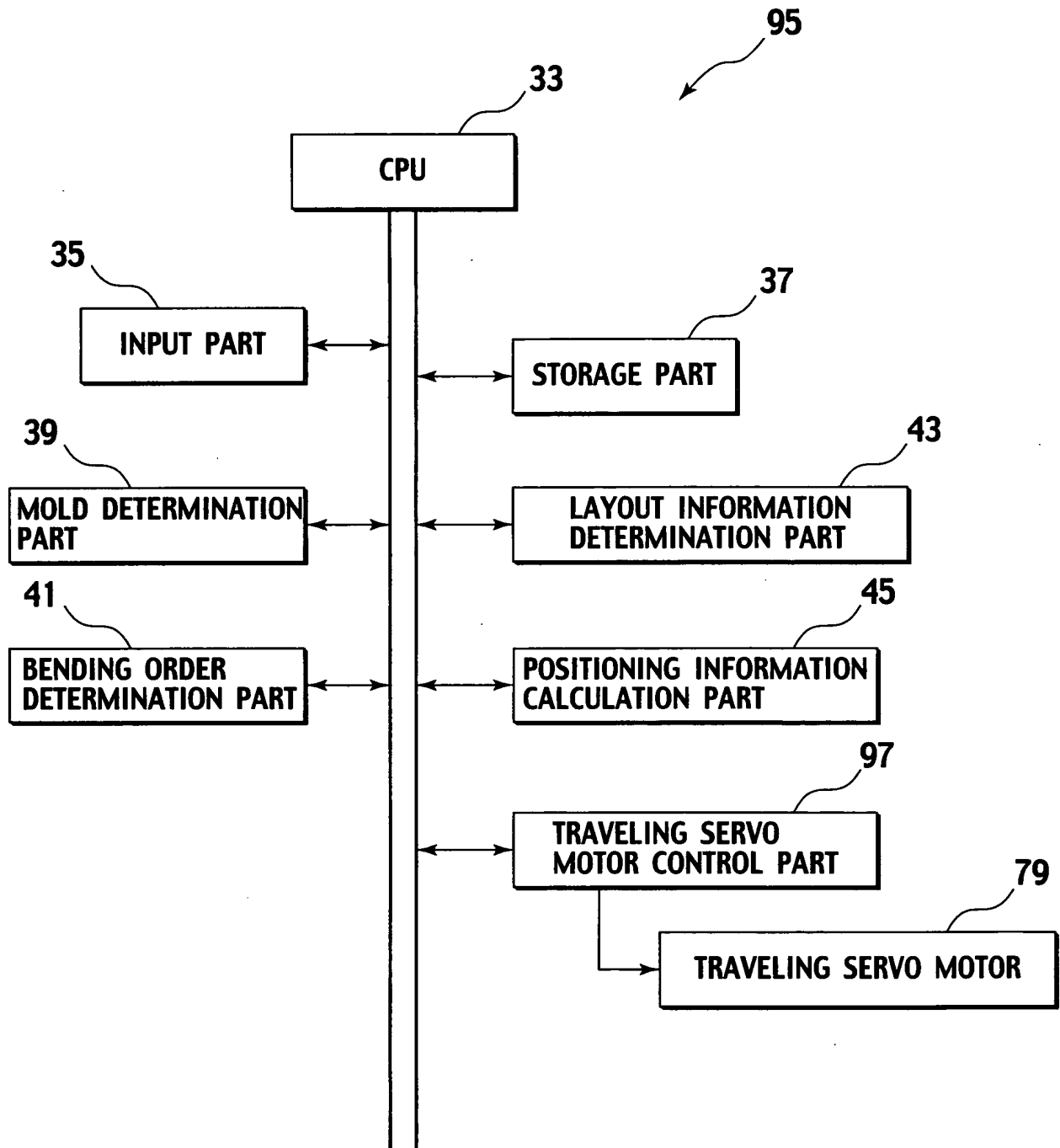
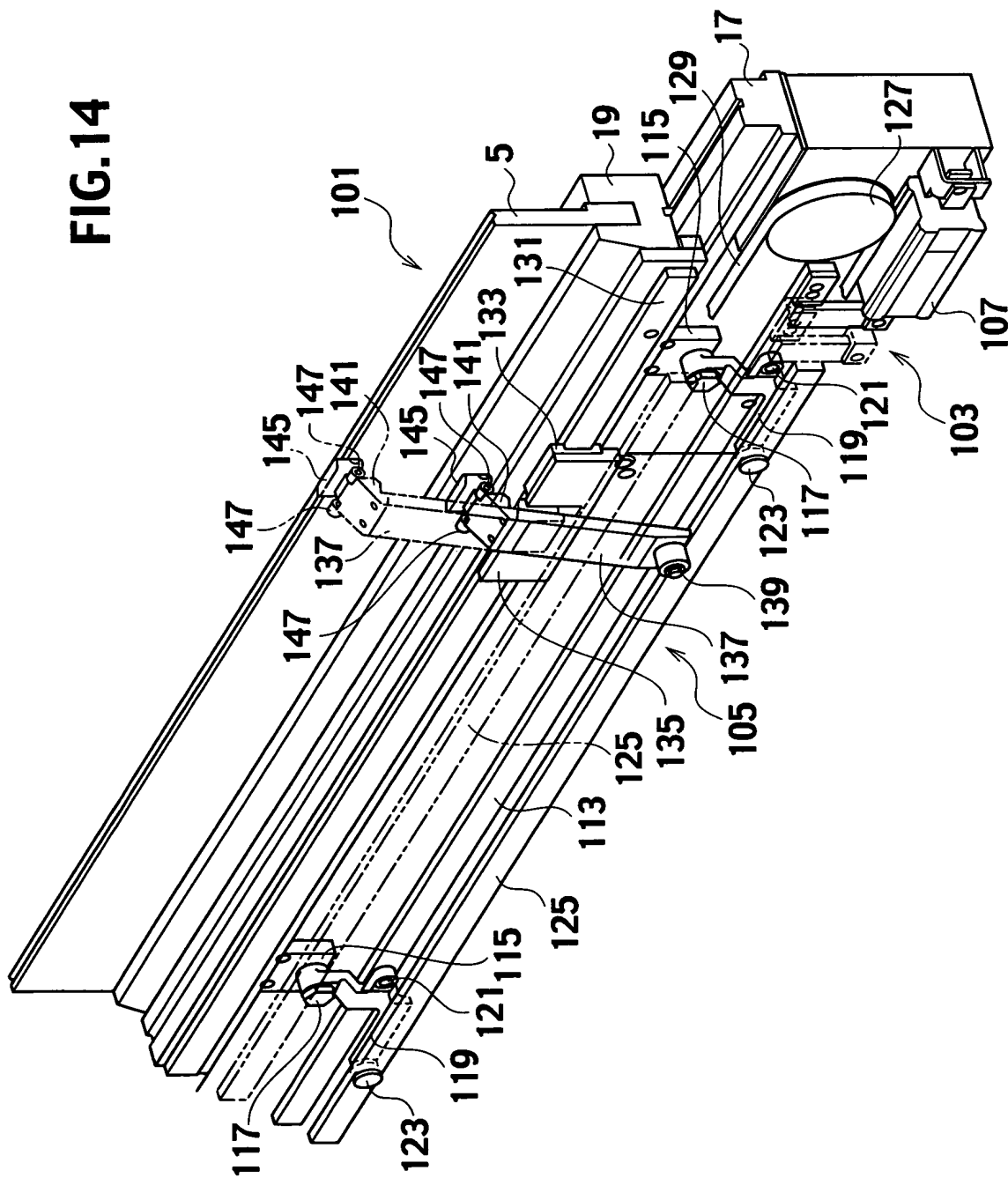
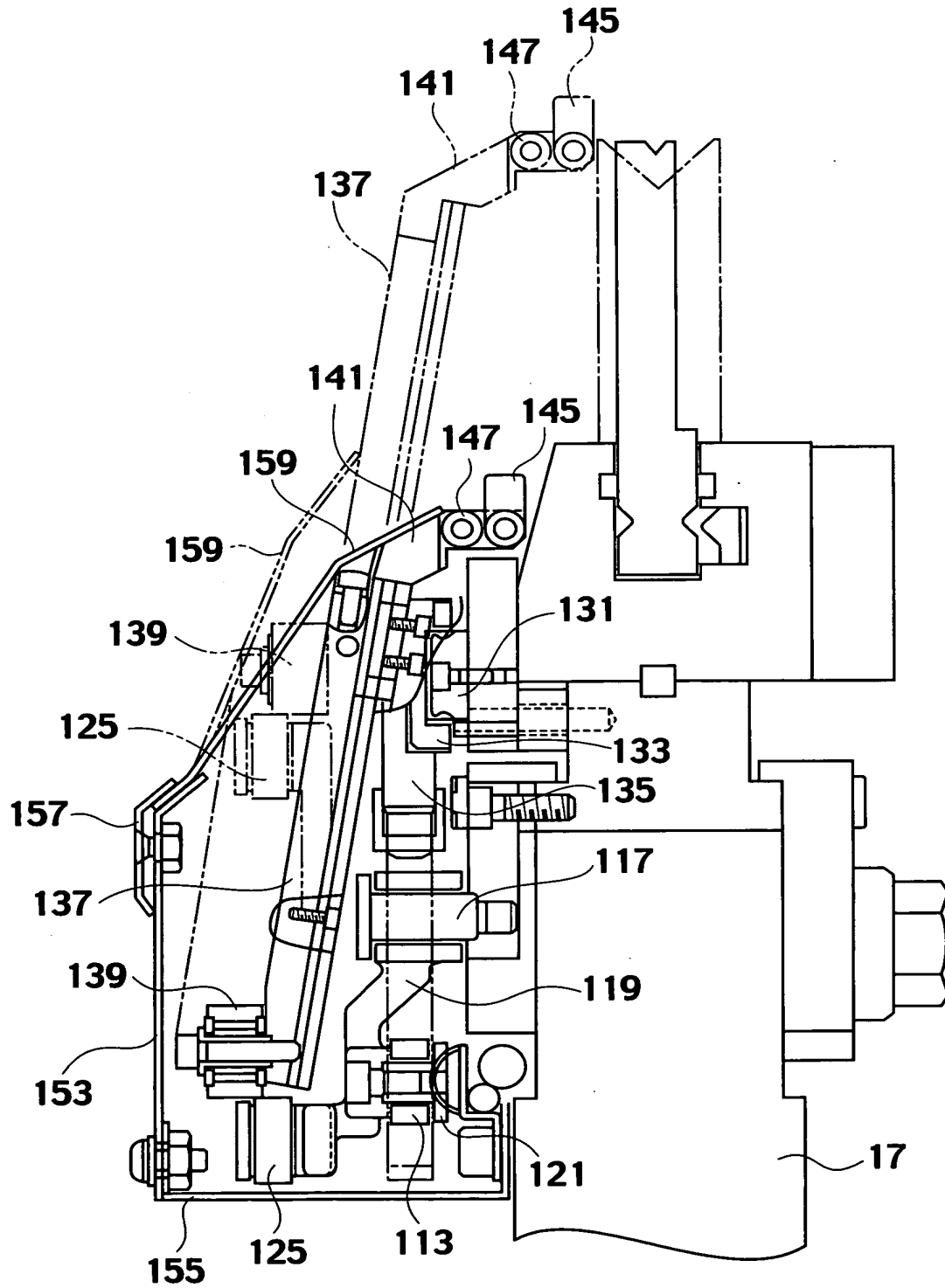


FIG.14



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FIG. 16



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FIG. 17A

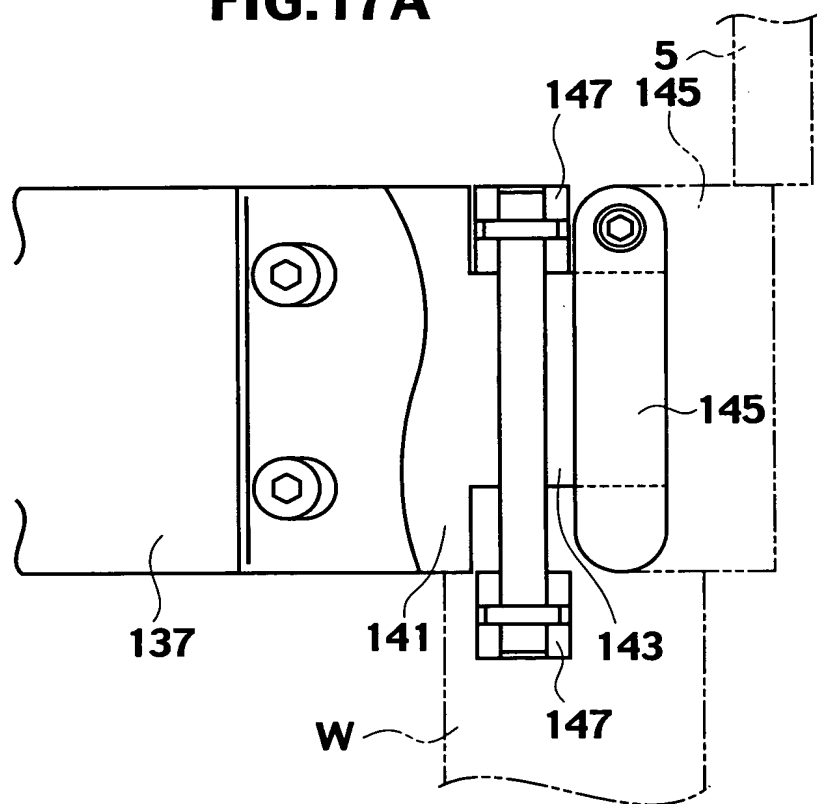


FIG. 17B

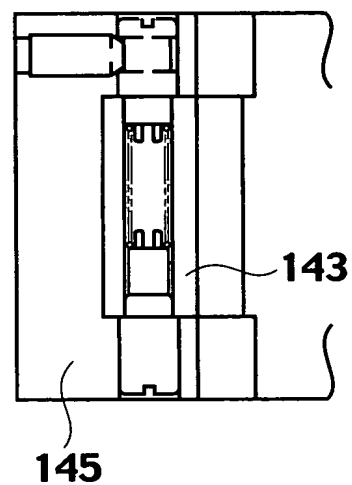
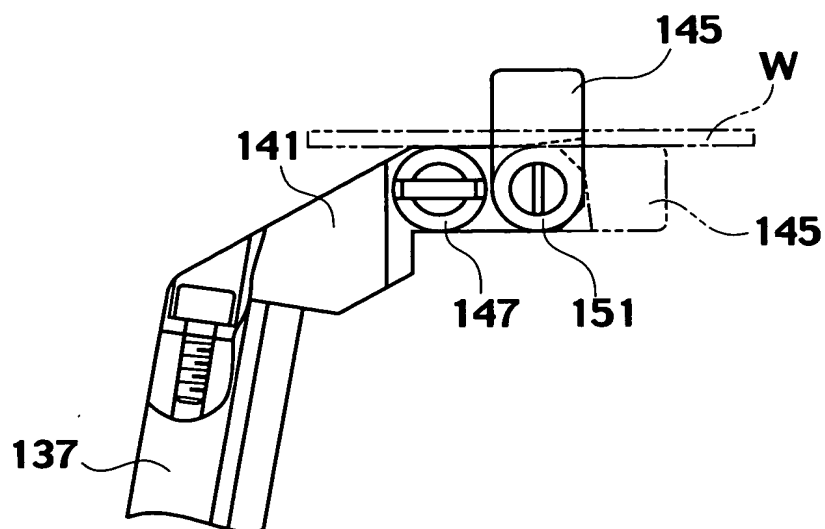
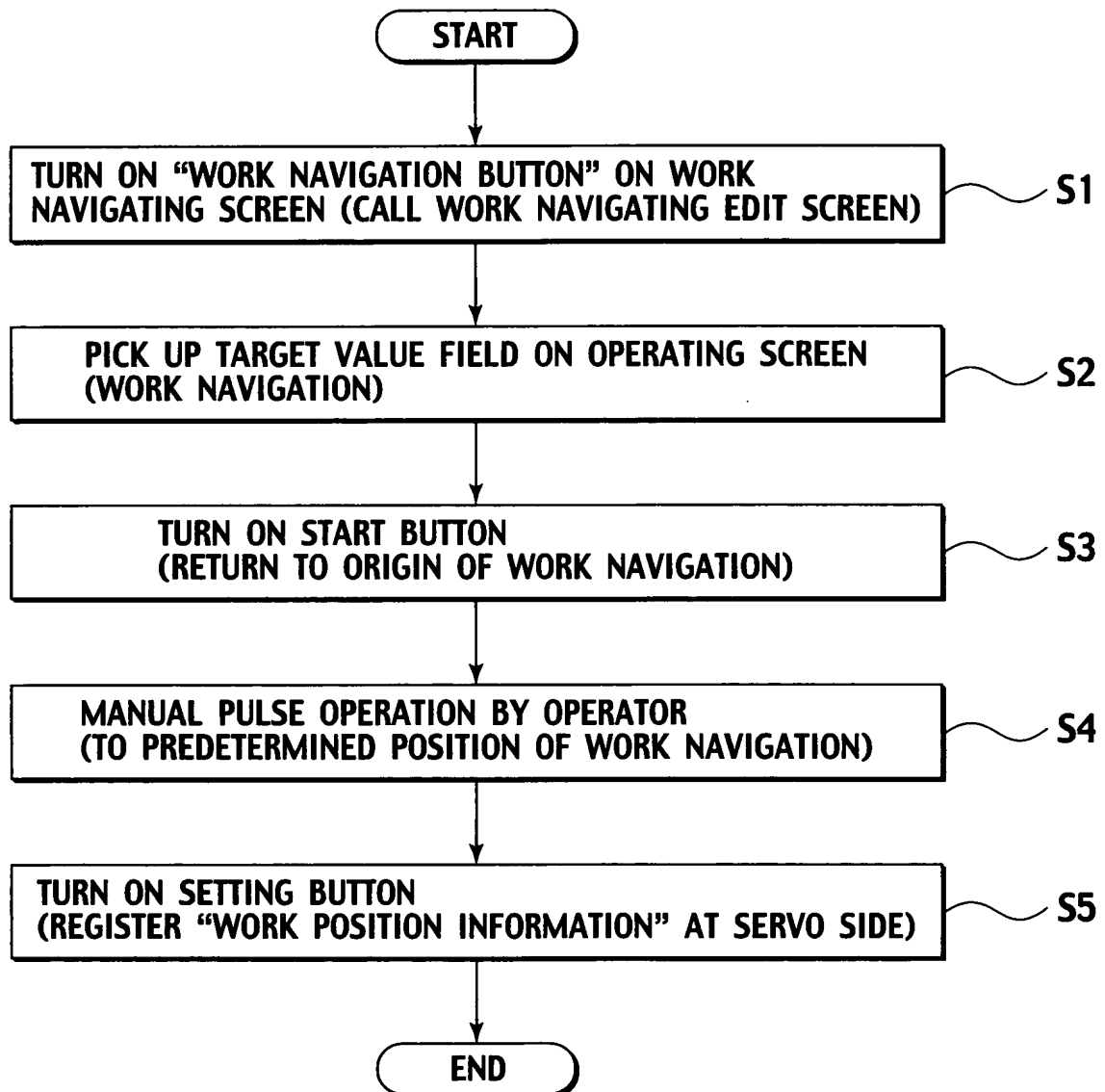


FIG. 17C



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FIG.18

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FIG.19A

PRODUCT NAME: SAMPLE-01 DATE: 2003/06/21 10:49:07

253

PROCESS 1/6 SET-UP 1/1 α ☐ NUMBER OF PROCESSES ☐/ ☐

β ☐ -2.00 NUMBER OF TIMES R ☐/ ☐

SIZE: 12.09 α' TIMER

ANGLE: 38.00° β' 1 2.0

V WIDTH: 8 PULLBACK

INNER R: 1.0 D' -0.1 F 6 L' 10

CC 184 SLOW DOWN

Y1 -500.5 SD 0.2 SF 4 SI 0.0

Y2 -271.5 STOPPING PRESSURE

Z -3.0 US 22.0 PE 9.6

BION

: W/N ON:

INPUT AN L-AXIS TARGET VALUE

160

159

WORK NAVIGATION

0 9 8 7 6 5 4 3 2 1

+ - .

↔ ↔

↕ ↕

↶ ↷

FINISH STORAGE

FIG. 19B

FIG. 1

161 157 163 165 253 160 167 159

PRODUCT NAME: SAMPLE-01

PROCESS 1/6 SET-UP 1/1 TARGET VALUE 1020.70 STRIKING DIRECTION 0 PULL SIDE AMOUNT 3.0 RETRACT POSITION 0 5mmUP 0(Absence)/1(Presence)

VALID/INVALID 1/0	TARGET VALUE	STRIKING DIRECTION 0(RIGHT)/1(LEFT)	PULL SIDE AMOUNT	RETRACT POSITION	5mmUP 0(Absence)/1(Presence)
1	1020.70	0	3.0		0
2	-1200.50	1	3.5		1
3	0			-1300.00	
4	-900.00	1	15.0		0

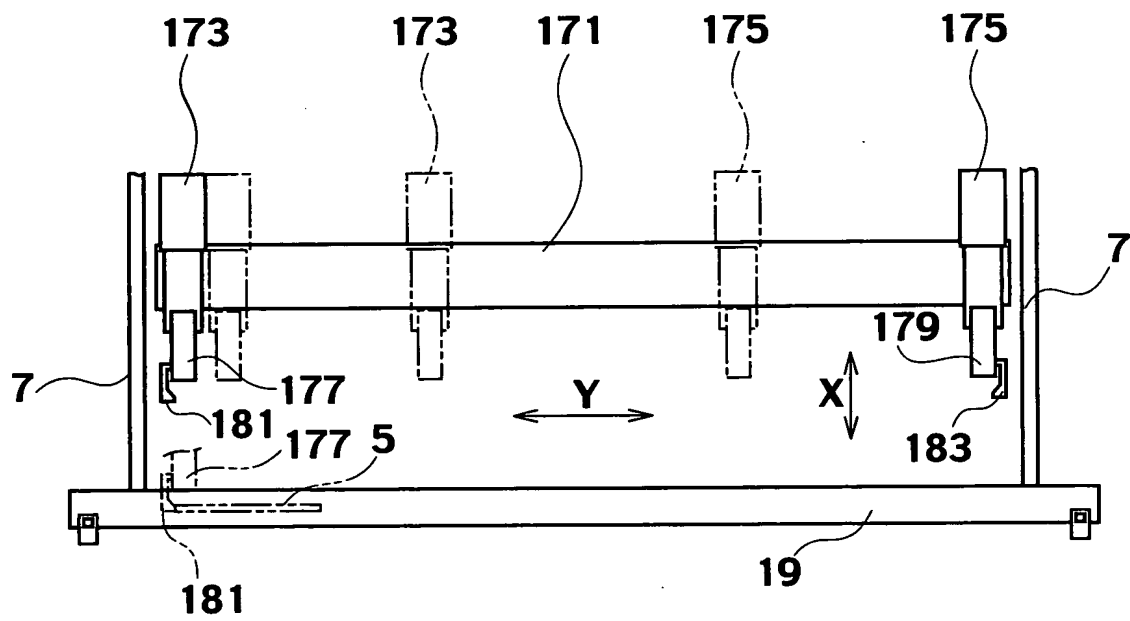
W/N ON

FINISH STORAGE

INPUT A SPRING BACK AMOUNT

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FIG.20



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FIG.21

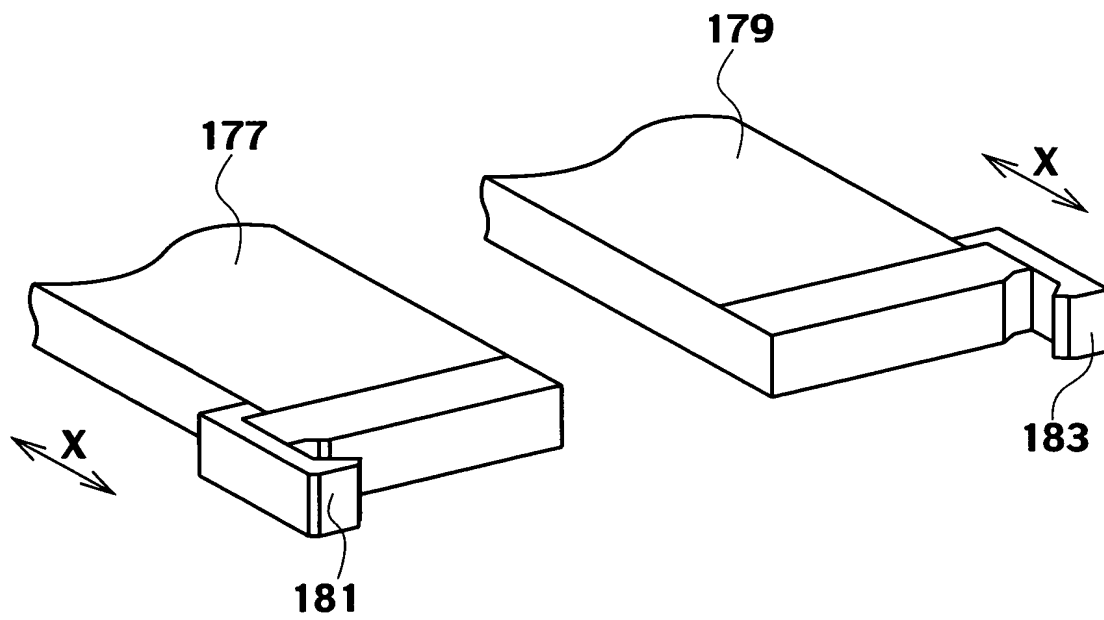


FIG.22B

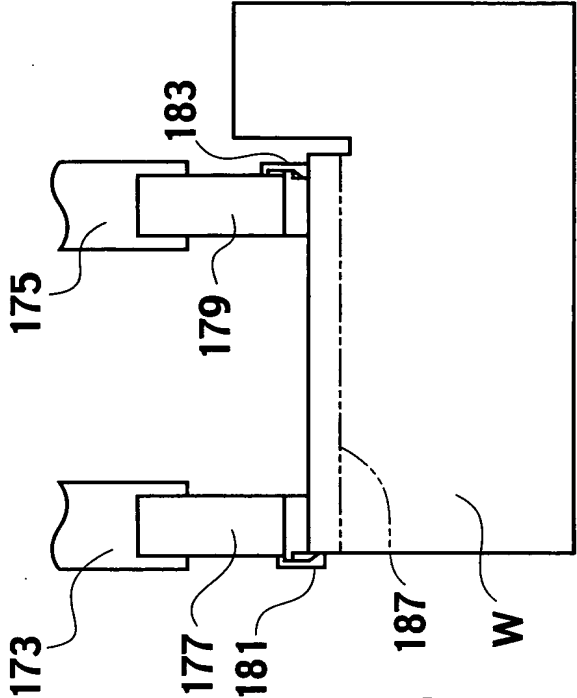


FIG.22A

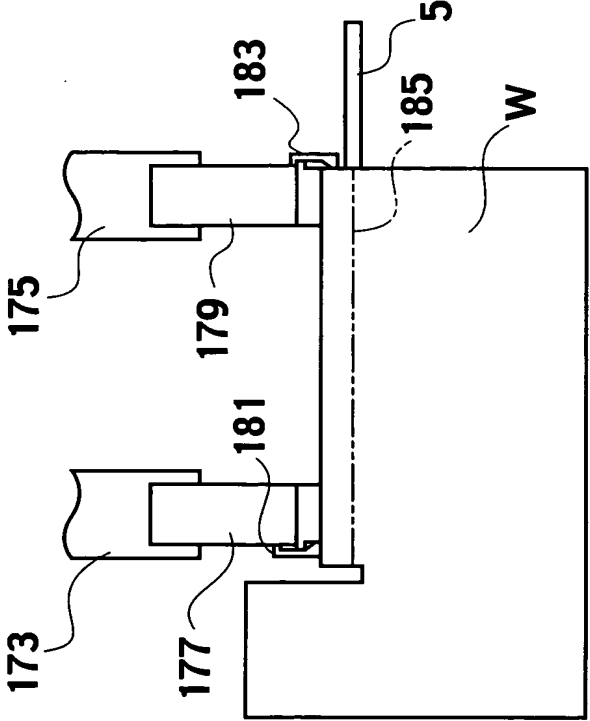


FIG.23

